

Work Order ID: **75446*****75446***

Page#1

October-21-11 2:45:31 PM

Item ID: D3572-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Guide Assembly

Start Date: 21/10/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: M.C.JDate: 11/10/27

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

11/10/27 (6)11/10/27 (6)5/11/10/27

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID 75446

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Item ID: D3572-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Guide Assembly
 Start Date: 21/10/2011 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 10/11/2011 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>M19785</u> Large Fab Memo 1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 2- grind weld flush at the end of tube only	0.00 0.00							
									<u>02</u> <u>12-3-19</u> <u>(X6)</u>
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
									<u>x6</u> <u>0</u> <u>BB12-03-20</u>
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
									<u>6</u> <u>12/3/20</u>

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 Item Name: Guide Assembly
 Start Date: 21/10/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/11/2011 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>6</u> <u>7/6</u>	<u>12-3-21</u>		
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <u>8h20</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>8h50</u>	0.00 0.00				<u>6</u> <u>Q</u> <u>SP</u>	<u>12/03/26</u>		
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>6</u> <u>6</u> <u>ll</u>	<u>u/63/20</u>		

M118489

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 Required Date: 10/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location <u>260</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/3/26 (6) SP

MLJ 12/03/27

12-03-27

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Picklist Print

Page 1

October-21-11 2:45:36 PM

Work Order ID: 75446

75446

Parent Item: D3572-041

D3572-041

Parent Item Name: Guide Assembly

Start Date: 21/10/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-07 JLM

IPP rev B revB dwg EC

IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM

IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			110	f	86.5224	2.34	14.77895			
M6061T6T1 000W 188													
6061T6 RD TUBE 1.00 X .188W													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT016	86.522368						
						109041	3						
						114089	5.147368						
						115868	6.375						
						117795	72						
D3572-3		Manufactured	No			130	Each	36.0000	4	24			
D3572-3													
Guide													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA	20						
						69891	20						
						WA030	16						
						65255	16						
D3572-5		Manufactured	No			130	Each	20.0000	1	6			
D3572-5													
Bracket													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA	18						
						69934	18						
						WA030	2						
						65100	2						

11/10/27

117797
14.77895

12-3-19

12-3-19

69891 x20
74506x4

69934 x6

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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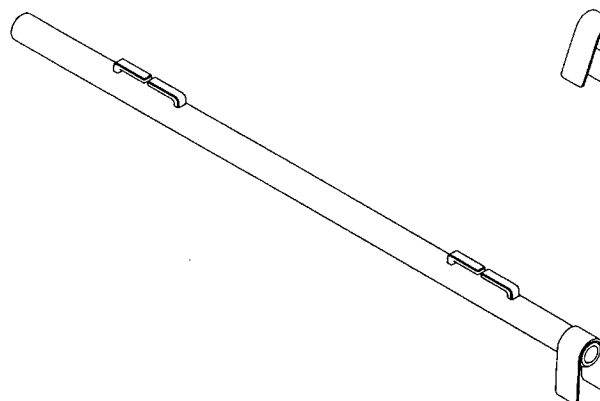
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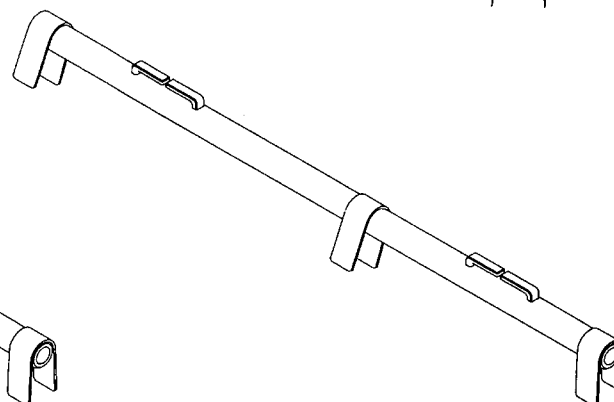
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ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

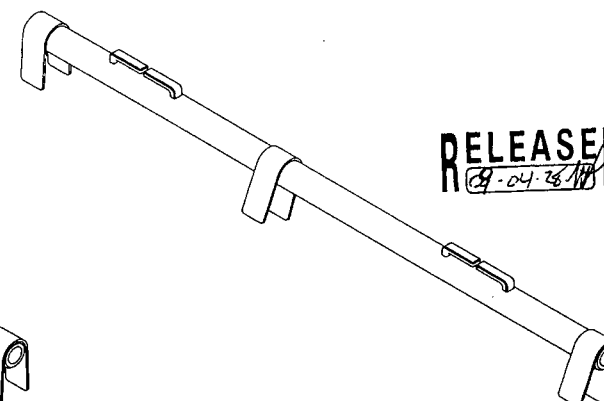
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75446 H.L.J
11/10/24



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
09-04-28/17

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
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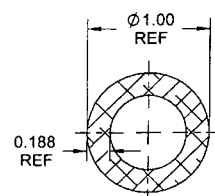
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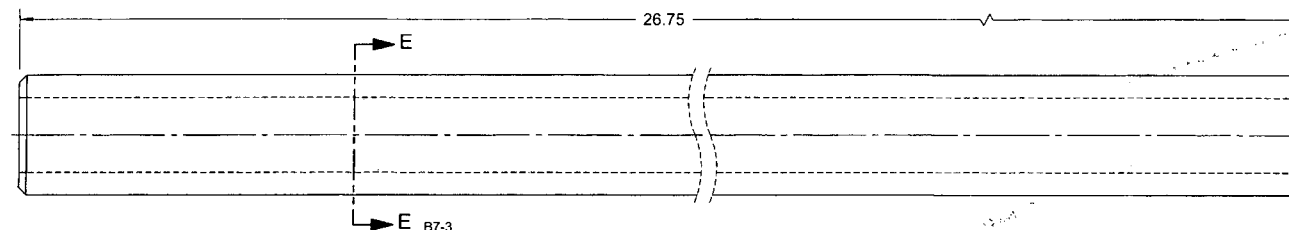
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75446



SECTION E-E C5-3



D3572-1 TUBE

0.06 X 45° CMF
MIN

RELEASED
07/04/13

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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CHECKED	JS	DRAWING NO. D3572	REV. D SHEET 3 OF 4
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DE APPR.	JS		
DATE	09.04.17		

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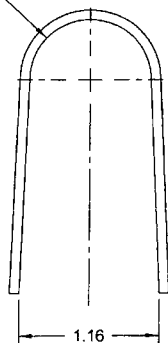
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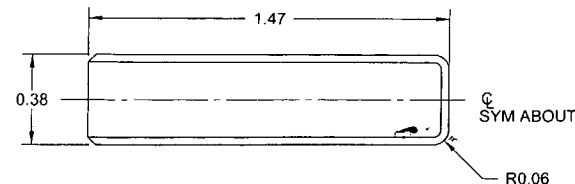
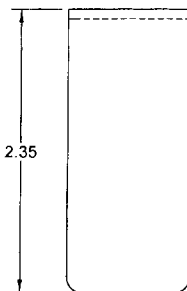
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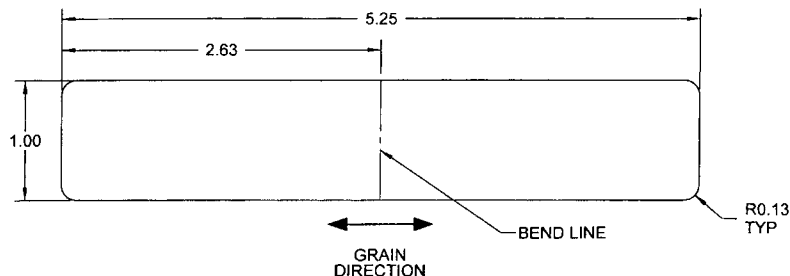
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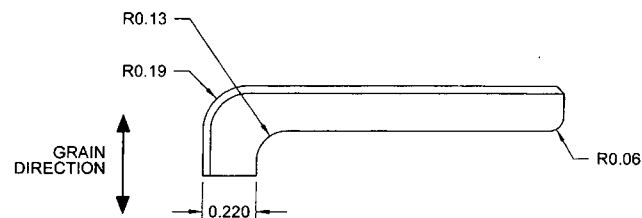
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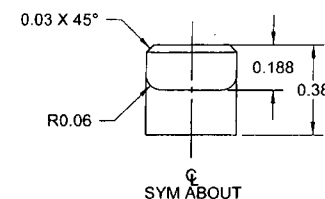
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



RELEASED
9/04/18

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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